

Date: Monday, 20/04/2009 1:01:39 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 47302	
Estimate Number : 10606	
P.O. Number :	Part Number : D33193
This Issue : 20/04/2009 S.O. No. :	Drawing Number : D3319 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 46859	Material :
Written By :	Due Date : 04/05/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JUL 09 04 20</u>	
Comment : Est: A 05.05.12 New issue KJ/JLM Est Rev:B Now on Waterjet 06-10-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S18GA	1010/1025 SHEET .048
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Comment: Qty.: 3.4150 sf(s)/Unit Total : 34.1502 sf(s)

1010/1025/A21/6aA SHEET .048" Thick

Batch: 110996 AB 9-5-7

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3319

Dwg Rev: B

Prog Rev: B

AB 9-5-7



2-Deburr if necessary AB 9-5-7

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

AB 9-5-7

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

80205107 (x4)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

AS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 20/04/2009 1:01:39 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 47302

Part Number: D33193

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form using DT8326 & DT8261 as per Dwg D3319 Rev: B

SB 07/05/08

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 07/05/11 (X11)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev: _____

Qty Part Number Description Batch

A/R N/A

7560 Hardcoat Rod

11109813

EL 9-5-12 (X11)

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 07/05/12 (X11)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 07/05/12 (X11)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

11109091

START TIME:

11:05

OVEN TEMPERATURE:

300°

FINISH TIME:

11:35

PR 09-05-12 (11)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

09-05-12 (X11)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 20/04/2009 1:01:39 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 47302

Part Number: D33193

Job Number:



Seq. #:

Machine Or Operation:

Description :

P/N: D3319-3, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location: _____

ST 497

88 09/05/13 (11)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/13

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mr
09-05-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47302
Description: Wearplate		Part Number: D3319-3
Inspection Dwg: D3319	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

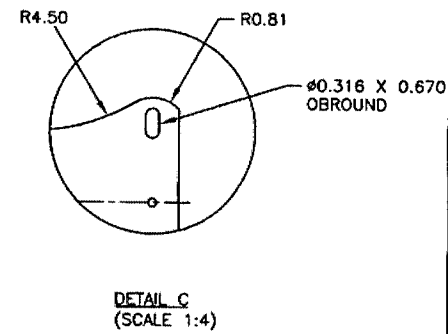
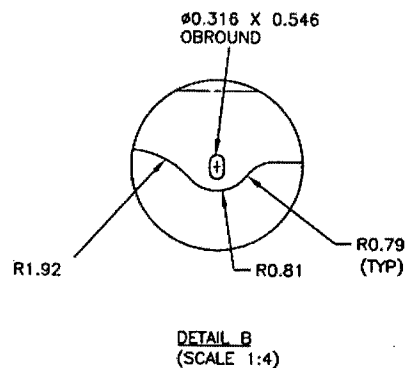
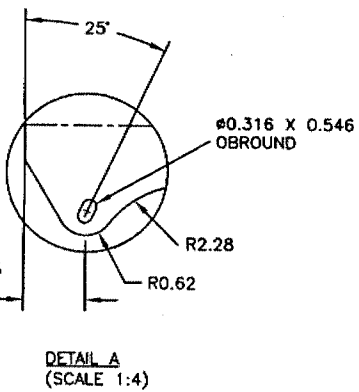
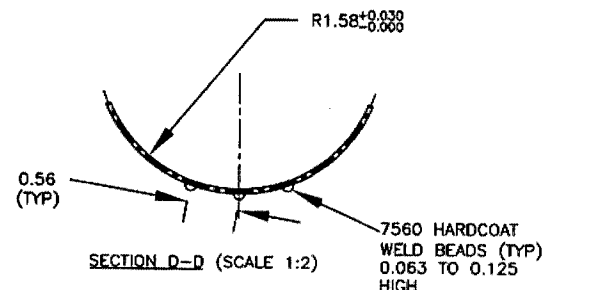
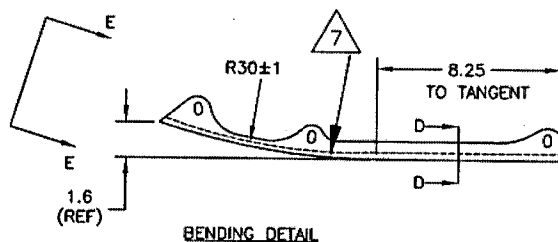
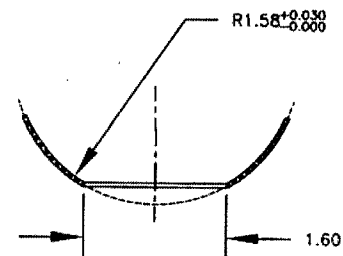
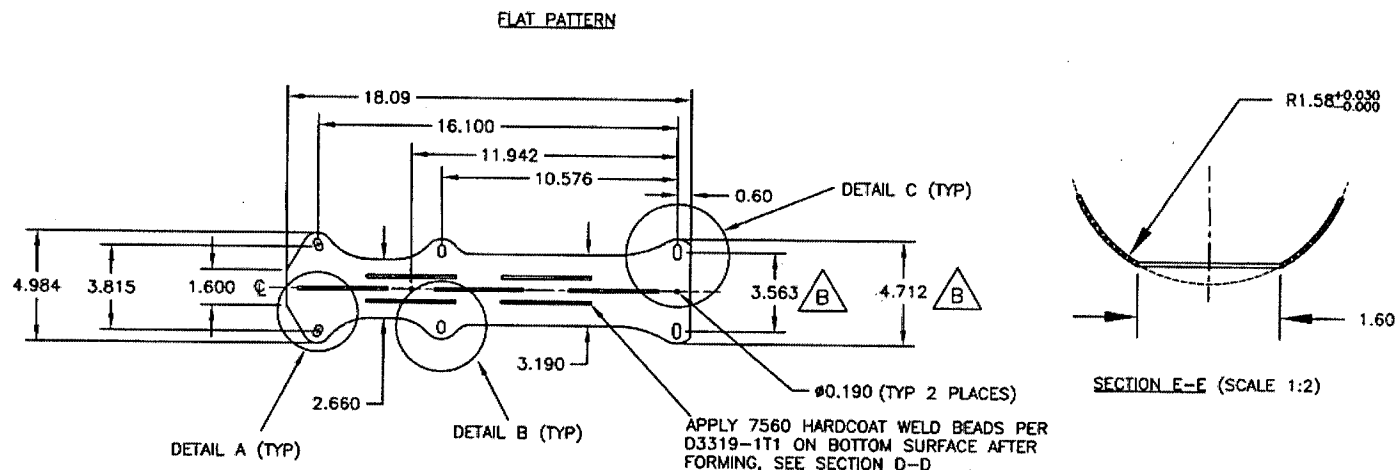
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
75.52	+/-0.030	75.52	X			
74.420	+/-0.010	74.420	✓			
62.770	+/-0.010	62.770	✓			
52.890	+/-0.010	52.890	*			
30.790	+/-0.010	30.790	X			
8.690	+/-0.010	8.690	✓			
0.60	+/-0.030	.599	X			
2.690	+/-0.010	2.694	X			
2.940	+/-0.010	2.949	✓			
3.527	+/-0.010	3.524	*			
4.518	+/-0.010	4.514	X			
Ø0.190	+0.005/-0.001	.194	X			
2.940	+/-0.010	2.946	X			
2.940	+/-0.010	2.946	X			
2.690	+/-0.010	2.697	X			
5.063	+/-0.010	5.061	X			
6.163	+/-0.010	6.163	X			
Ø0.316 x 0.607	+0.006/-0.001 x +/-0.010	320x610	X			
0.048	+/-0.010	.048	✓			

Measured by: HB	Audited by: S	Prototype Approval: N/A
Date: 9-5-7	Date: 09/05/07	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	BE

DART



D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N 8XXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DESIGN	DRAWN BY	DART AEROSPACE LTD
041	041	HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
041	041	D3319
DATE	TITLE	SCALE
05.06.06	WEARPLATE	1:8
A	04.09.24	NEW ISSUE
B	05.06.06	WIDEN HOLES, REDUCE WIDTH -3/-5/-7

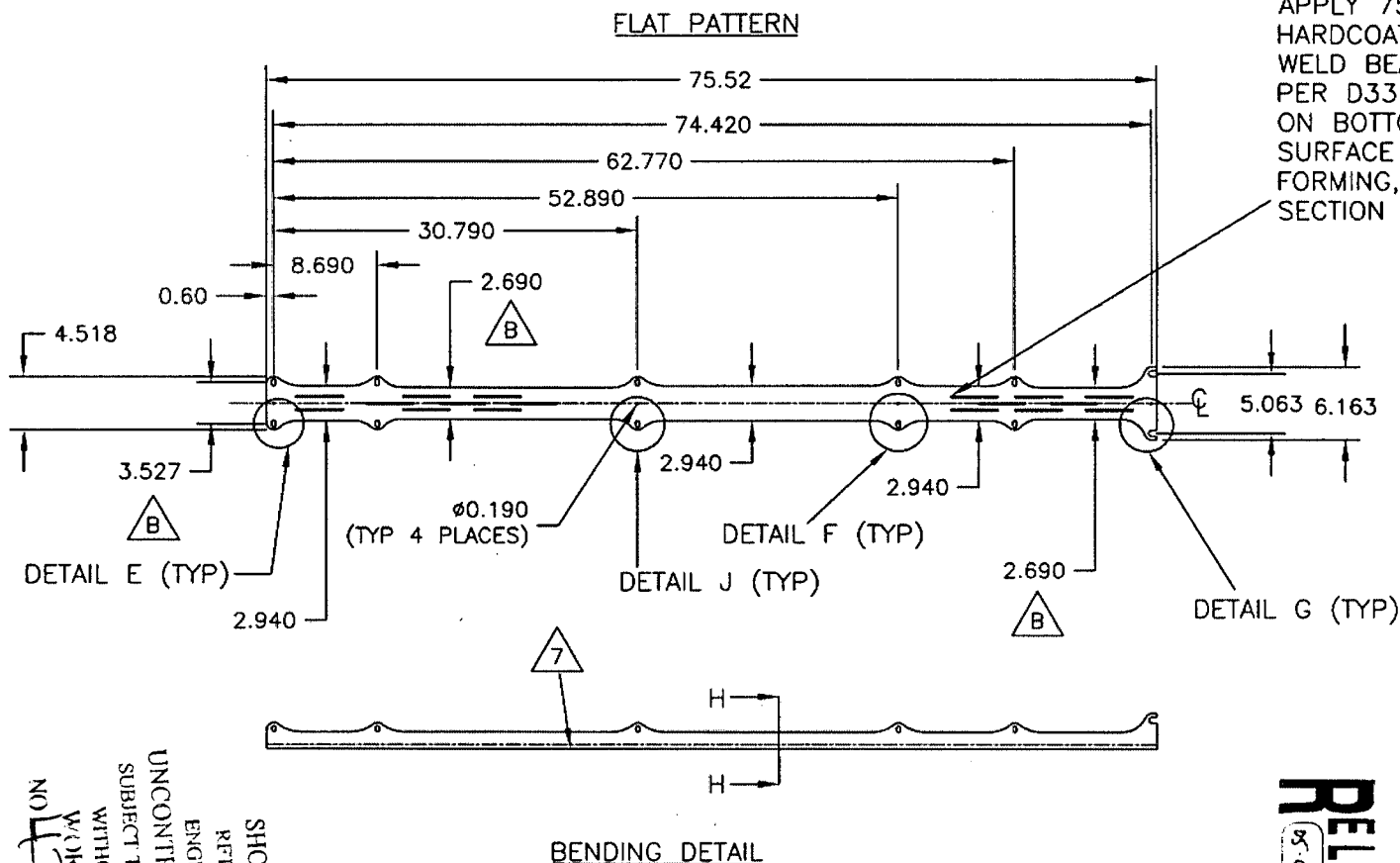
RELEASED
05-09-30-11

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. B
05.06.06	D3319	SHEET 2 OF 5
	TITLE	SCALE
	WEARPLATE	1:15

APPLY 7560
HARDCOAT
WELD BEADS
PER D3319-3T1
ON BOTTOM
SURFACE AFTER
FORMING, SEE
SECTION H-H





RELEASED
05-01-30-18

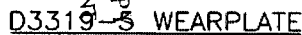
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RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 473003

D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
041	041		
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3319	SHEET 3 OF 5
DATE		TITLE	SCALE
05.06.06		WEARPLATE	1:5

05-07-30



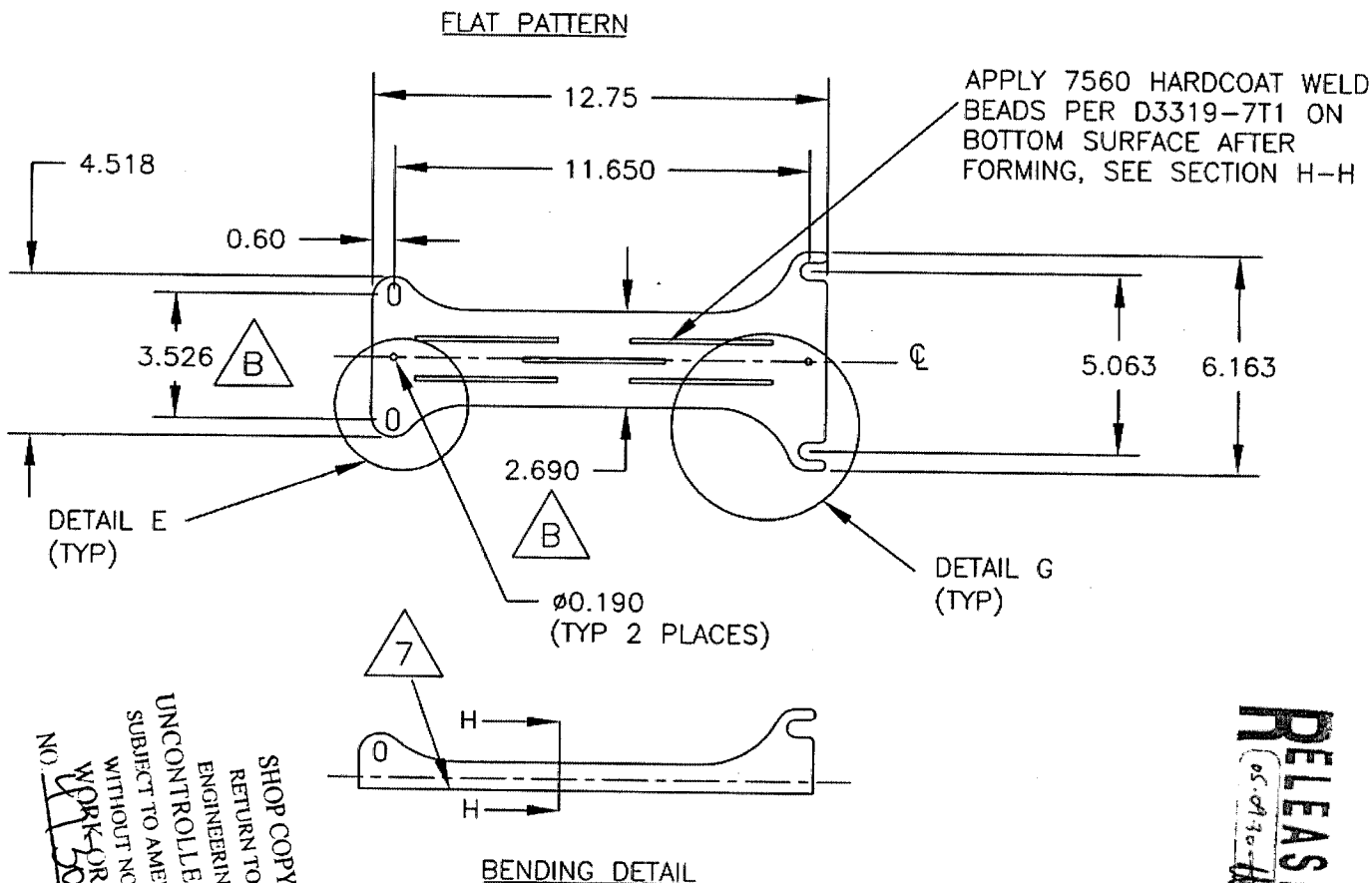
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DART

DESIGN	PH	DRAWN BY	GH	DART AEROSPACE LTD
CHECKED	PH	APPROVED	GH	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	TITLE	D3319	REV. B
			WEARPLATE	SHEET 4 OF 5
				SCALE 1:5

RELEASED
05-01-30-11

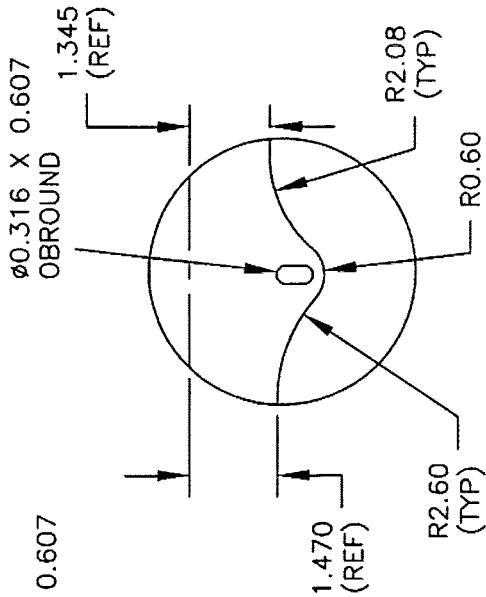
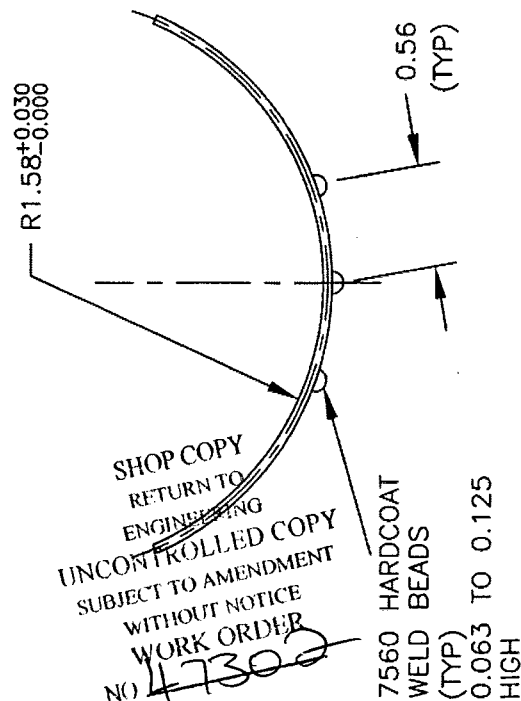
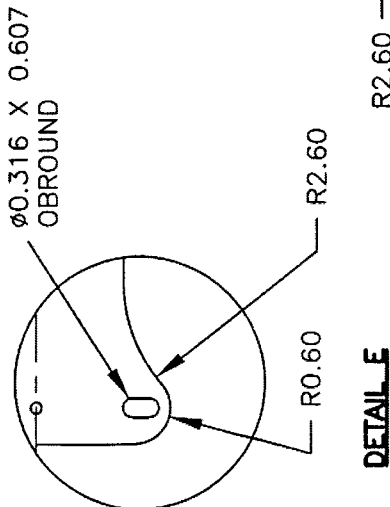
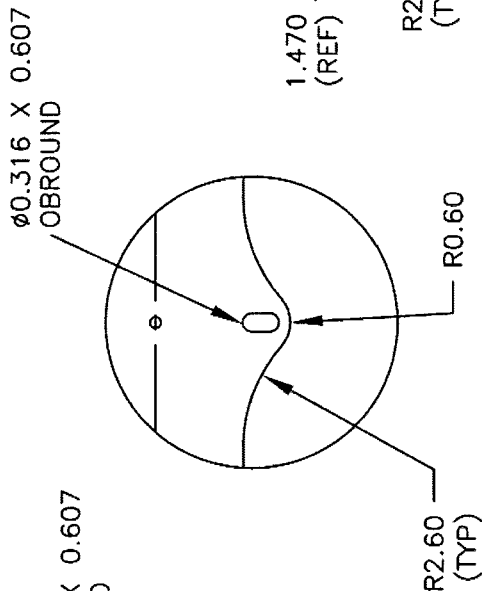
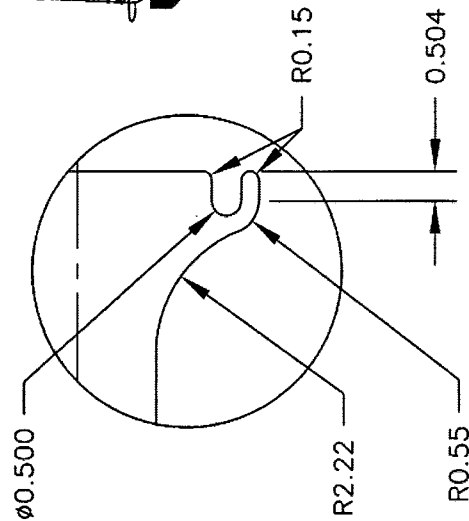


D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06		TITLE WEARPLATE	SCALE 1:3

**RELEASED**
05-09-30

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 47300

7560 HARDCOAT
WELD BEADS
(TYP)
0.063 TO 0.125
HIGH

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